



A CSW Industrials Company

# PRODUCT DATA SHEET

## ARCTIC™ 616L

### PVC Medium Body Solvent Cement

#### Description

Arctic 616L is a premium polyvinyl chloride (PVC) solvent cement used for joining PVC pipe and socket-type fittings through 6" for Schedule 40 and 4" for Schedule 80. Max VOC per SCAQMD 1168/316A or BAAQMD method 40: 510 g//L.

Arctic 616L is a clear, medium body cement that is specifically formulated to give optimum solvent welding penetration of pipe and fitting surfaces under low temperature conditions for maximum bond strength.

#### Instructions

1. Store and apply between 0°F and 120°F. Protect from freezing. Do not thin or use if cement has become curdled, lumpy or thickened.
2. Wear non-permeable gloves during application to avoid skin contact.
3. Clean fitting socket and pipe, and check for proper fit. Apply PRIMER to all PVC surfaces. While still wet, quickly begin solvent cement application.
4. Shake well before using and stir frequently while using. Apply with supplied dauber applicator. For pipe greater than 2" diameter, use natural-bristle brush sized 1/2 of the pipe diameter.
5. Apply thin coat evenly to socket. Avoid puddling. Quickly apply heavy coat to pipe end. While wet, quickly insert pipe into fitting with slight twisting movement until it bottoms out.
6. Hold pipe into fitting for at least 30 seconds to prevent pipe backing out.
7. Wipe excess cement from joint with rag. Allow 15 minutes before handling. Avoid full-line pressure for 24 hours. Cure times varies with size, fit, temperature and humidity.

#### Applications

Arctic 616L is formulated for use on all PVC pipe applications such as potable water, pressure pipe, gas, conduit, sewers, and drain, waste and vent (DWV). It is for use on PVC pipe through 6" Schedule 40 and 4" Schedule 80.

Special Note - All solvents evaporate slower at lower temperatures. Even though Arctic 616L will dry at temperatures below 40°F, the colder the temperature, the slower the drying rate. The PVC joint cure schedule for cold weather listed in ASTM D2855 can be used as a guideline for drying times for Arctic 616L for application at temperatures below 40°F. Extreme care should be exercised on all joints made in temperatures below 10°F.

#### Packaging

Code	Size	Qty. per Case	Lbs. per Case	Cubic Ft per Case
55919	Pint Dauber top (473 ml)	12 Cans	15	.43
55948	Quart Dauber top (946 ml)	12 Cans	28	.78
55953	Gallon - Wide Mouth (3.8 L)	4 Cans	34	.80



#### Characteristics | Features

- Specifically designed for use in cold weather
- Remains stable from 0°F to 120°F - can be used year-round
- NSF approved for potable water
- Medium body - reduces product run-off and has excellent gap filling characteristics
- UPC (IAPMO) listed under File No. 1796
- LEED Compliant
- Exceed ASTM D2564 specifications

# ARCTIC™ 616L

PVC Medium Body Solvent Cement

## Specifications

Wt/Gal @ 77°F	7.5 lbs./gal.
Flash Point SETA CC	3° F
Color	Clear
Shelf Life	2 years



FILE NO. 1796



pw-dwv-sw

Suggestions and recommendations covering the use of our products are based on our past experience and laboratory findings. However, as we have no control as to the methods and conditions of application, we only assume responsibility for the uniformity of our products within manufacturing tolerances.

## Precautionary Statements

Refer to Safety Data Sheet (SDS).

### KEEP OUT OF REACH OF CHILDREN

**FOR CHEMICAL EMERGENCY, SPILL, LEAK, FIRE, EXPOSURE OR ACCIDENT, CALL CHEMTREC - DAY OR NIGHT 1-800-424-9300**

For additional Technical Information Call Toll Free 1-800-231-3345

## Limited Warranty



For more information on our product limited warranty, visit [RectorSeal.com](http://RectorSeal.com)

Manufactured by

**RectorSeal, LLC**

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